

Date: Wednesday, 21/01/2009 7:38:10 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE
 Job Number : 44989
 Estimate Number : 13427
 P.O. Number :
 This Issue : 21/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 41868
 Written By :
 Checked & Approved By : MF 09-01-21
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Part Number : PB6743001211
 Drawing Number : B6743001 P.17
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 27/01/2009 Qty: 139 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6TS1000W120 6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.1156 f(s)/Unit Total : 160.6500 f(s)
 6061T6 SQ TUBE 1.00 X 0.120 wall

batch:

2109928(100) 11110680 (40)

44.624

SAD

09-01-29

139



2.0 SMALL FAB 1 (11.56) SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.050" chamfer on both ends of tube
- 3- deburr

SAD 09-02-05

139

139

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/06 (139) counts

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

09/02/06 (139)

3x35 1x34

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/09

Job Completion



MF 09-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

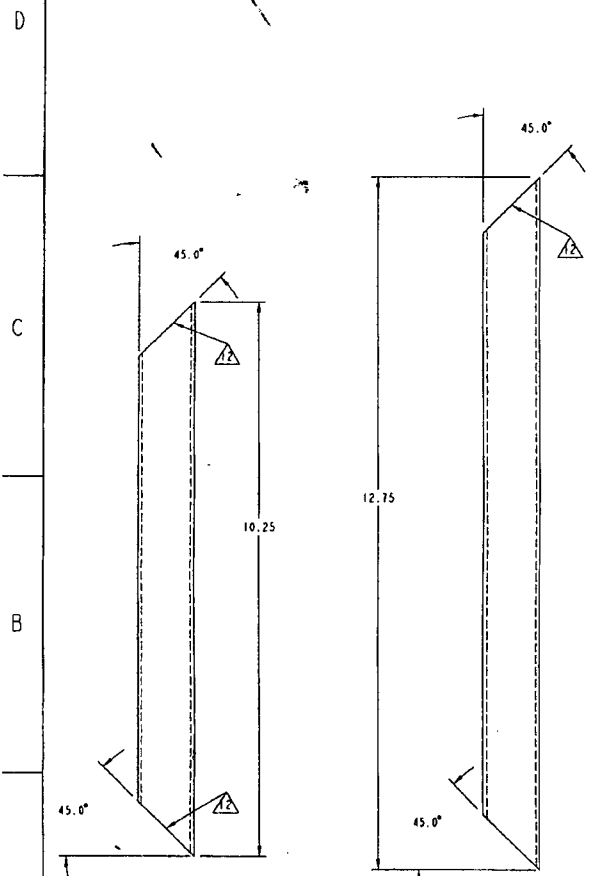
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

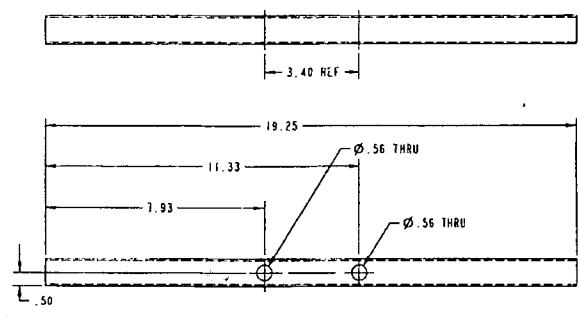
RELEASED
#00 01.20

REPLACED BY
SUPERCEDED BY
D3440-13

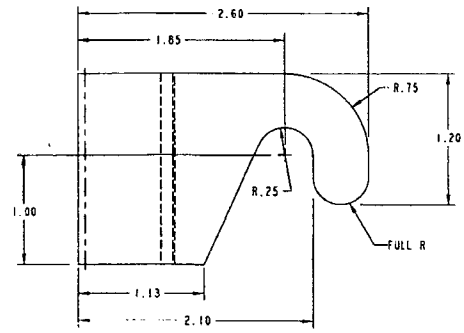
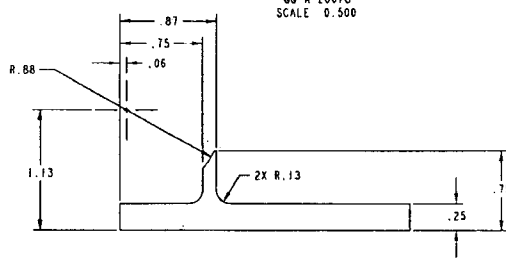


② -209 SQUARE TUBE
MATL: 1.00 SQ X .065 WALL, 6061-T6
QQ-A-200/8
SCALE 1.000

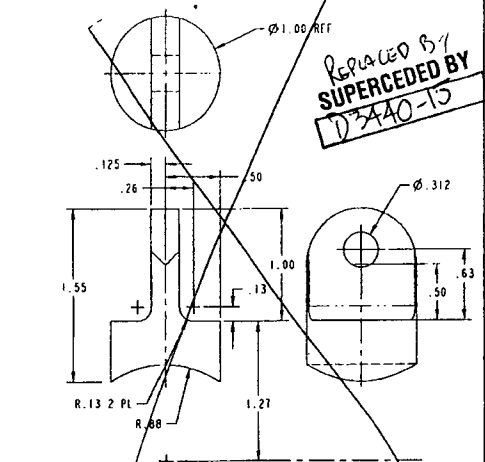
② -211 SQUARE TUBE
MATL: 1.00 SQ X .065 WALL, 6061-T6
QQ-A-200/8
SCALE 1.000



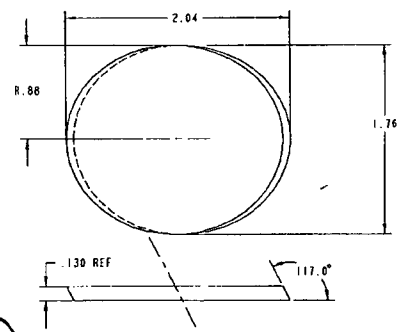
② -203 SQUARE TUBE
MATL: 1.00 SQ X .065 WALL, 6061-T6
QQ-A-200/8
SCALE 0.500



② -213 FLANGED HOOK
MATL: 6061-T6 QQ-A-200/8
SCALE 2.000



① -215 CONTOURED MALE EYE
MATL: 1.00 RND, 6061-T6
QQ-A-200/8
SCALE 2.000



② -199 OUTER TUBE END CAP
MATL: .125 THX, 6061-T6
QQ-A-250/11
SCALE 2.000

PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75052
LUN CORP. PART NO. (PAC NO.)
D3440-13 B67-43001 B1
SCALE: 1:1 11 of 45

ORIGINAL